



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.3610
Job Sheet 168239-A



Part No: 646.3610

Job Qty: 6 ea

Part Name: Filler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/21/17

Created By: Linda Lacelle

Type: Stock

Description:

Customer: Avialta Helicopter Maintenance Ltd (CAVIA05)

1A 27018 Sh 633 Villeneuve Airport Sturgeon County, AB, T8T 0E3 Canada ph:(780) 460-1800 fx:(780) 458-7311.

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		11/20/17	0.00	0.00	Start Up Container		
105	Bandsaw	6 pcs		11/20/17	0.00	0.30	Bandsaw1		
110	CNC Vertical Machining	6 pcs		11/21/17	0.20	1.94	HAAS 1		
120	QC	6 pcs		11/21/17	0.00	0.00	QC2		
130	QC	6 pcs		11/21/17	0.00	0.00	QC8		
140	Outsource	6 pcs		11/21/17			ATG001-VC	5	
150	Packaging	6 pcs		11/21/17	0.00	0.00	Packaging2		
155	QC	6 pcs		11/21/17	0.00	0.00	QC5		
180	Packaging	6 pcs		11/21/17	0.00	0.00	Packaging3		
190	QC21-SA	6 Ea		11/21/17	0.00	0.00	QC21		

Part Op 105 - Cut blanks at 4.90"

Descriptions: 110 - 1-Machine per DWG AND FOLIO FB493 FOLIO REV: _____

140 - Issue P/O to ATG : _____ 1- Black Anodize as per Dwg 646.3600

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

DAS
21
S-09

JAN 19 2016

JAN 17 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B0.750X01.000	3	30	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Filler	5Inches ± 0	5 5		
2	Filler	4Inches ± 0	4 4		
3	Filler	1Inches ± 0	1 1		
4	Filler	1Inches ± 0	1 1		
5	Filler	0Inches ± 0	0 0		
6	Filler	0Inches ± 0	0		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Machin' ☐ Thermoform ☐ Large ☐																																																																																									
Date : _____		Step #: _____		QTY E _____																																																																																									
Description Work Order Deviation Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																																																																													
Root Cause <table style="width:100%; font-size: x-small;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table> <table style="width:100%; font-size: x-small;"> <tr><td>Pressure/Forced</td><td>☐</td><td>Temperature/Ci</td><td>☐</td></tr> <tr><td>Bending</td><td>☐</td><td>Set-up</td><td>☐</td></tr> <tr><td>Centre Not Concentric</td><td>☐</td><td>BOM/Route</td><td>☐</td></tr> <tr><td>Cracks</td><td>☐</td><td>Broken/Damage</td><td>☐</td></tr> <tr><td>Crimp/Kink/Ripple/Wave</td><td>☐</td><td>Inspection Incon</td><td>☐</td></tr> <tr><td>Cuffs</td><td>☐</td><td>Contamination</td><td>☐</td></tr> <tr><td>Crushing</td><td>☐</td><td>Countersink</td><td>☐</td></tr> <tr><td>Heat Treat</td><td>☐</td><td>Cut Too Short</td><td>☐</td></tr> <tr><td>Wave/Twist in Tube</td><td>☐</td><td>Instructions Inco</td><td>☐</td></tr> <tr><td>Marks/Chatter</td><td>☐</td><td>Drill Holes</td><td>☐</td></tr> </table>						Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	Pressure/Forced	☐	Temperature/Ci	☐	Bending	☐	Set-up	☐	Centre Not Concentric	☐	BOM/Route	☐	Cracks	☐	Broken/Damage	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incon	☐	Cuffs	☐	Contamination	☐	Crushing	☐	Countersink	☐	Heat Treat	☐	Cut Too Short	☐	Wave/Twist in Tube	☐	Instructions Inco	☐	Marks/Chatter	☐	Drill Holes	☐
Environment	☐	No Re-verification	☐																																																																																										
Design	☐	Operator	☐																																																																																										
Doc/Data	☐	Offset/Setup	☐																																																																																										
Equip/Tooling	☐	Supplier	☐																																																																																										
Handling/Pre	☐	Training	☐																																																																																										
Material	☐	Use for Testing	☐																																																																																										
Internal Transport	☐	Poor Information	☐																																																																																										
Tribal Knowledge	☐	Rushing	☐																																																																																										
LOA	☐	Product Improvement	☐																																																																																										
Substation	☐	Process Improvement	☐																																																																																										
Past Expiry Date	☐	Manufacturing Process	☐																																																																																										
Misidentified	☐	Past Due	☐																																																																																										
Pressure/Forced	☐	Temperature/Ci	☐																																																																																										
Bending	☐	Set-up	☐																																																																																										
Centre Not Concentric	☐	BOM/Route	☐																																																																																										
Cracks	☐	Broken/Damage	☐																																																																																										
Crimp/Kink/Ripple/Wave	☐	Inspection Incon	☐																																																																																										
Cuffs	☐	Contamination	☐																																																																																										
Crushing	☐	Countersink	☐																																																																																										
Heat Treat	☐	Cut Too Short	☐																																																																																										
Wave/Twist in Tube	☐	Instructions Inco	☐																																																																																										
Marks/Chatter	☐	Drill Holes	☐																																																																																										
OTHER : _____																																																																																													

S021893


Filler

646.3610**PART NO:****Revision:****Start up Operation****Operation:****Change No:**

Mfg Date: 12/14/17

Job No: 168239 - A

 Approval

ed By

 Supervisor

 Coordinator

 Wrong
 Dimensions
 tolerance
 ct
 issing

ence

			0	
7	Filler	2Inches $\pm$ 0	2	
			2	
8	Filler	1Inches $\pm$ 0	1	
			1	
9	Filler	28Degrees $\pm$ 1	28	Angle
			27	
10	Filler	0Inches $\pm$ 0	0	
			0	

Plex 12/13/17 4:26 PM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038682

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
			Hard Anodize Black and Prime as Per Dwg 646.3800							
Line Item Note RUSH 7	168025	646.3813	AS350 Strut Bracket Issue P/O to ATG : Hard Anodize Black and Prime as Per Dwg 646.3800	Firmed	12/22/17	5 pcs	0 pcs	5 pcs	\$7.10/pcs	\$35.50
							15	22-12-17	md	
Line Item Note RUSH 8	168239-A	646.3610	Filler Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3600	Firmed	1/17/18	6 pcs	0 pcs	6 pcs	\$7.60/pcs	\$45.60
9	168239	646.3610	Filler Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3600	Firmed	1/17/18	12 pcs	0 pcs	12 pcs	\$7.60/pcs	\$91.20
							6x	12/1/18	md	
10	168280	647.0210	Rail Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3600	Firmed	1/17/18	11 pcs	0 pcs	11 pcs	\$11.50/pcs	\$126.50
							12x	12/1/18	md	
11	168223	646.3110	Channel Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3100	Firmed	12/22/17	6 pcs	0 pcs	6 pcs	\$11.65/pcs	\$69.90
							11x	12/1/18	md	
Line Item Note RUSH 12	168839	649.4813	Shim ISSUE P/O: As Per MPP-172 Section 2.1, Hard Anodize IAW MIL-A-8625, Type III, Class 2, Color Black As Per MPP-172 Section 4.2 Prime IAW MIL-P-23377J Type1 Class N	Firmed	12/22/17	20 pcs	0 pcs	20 pcs	\$7.25/pcs	\$145.00
							6x	22-12-17	md	
Line Item Note RUSH 13	169183	649.5212	Bracket Issue P/O to ATG : 1- Hard Anodize Black as per Dwg	Firmed	1/17/18	5 pcs	0 pcs	5 pcs	\$10.00/pcs	\$50.00
							20x	22-12-17	md	
							5x	12/1/18	md	



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914370

Date: 05-Jan-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577 Fax: 613 632-1999		Ship Via	
Terms		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
11 ea	Part: 647.0210 Rail Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 22198		Rev: N/C PO: PO038682 Line: 10
5 ea	Part: 649.5212 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22201		Rev: A PO: PO038682 Line: 13
20 ea	Part: 649.4812 Shim Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22193		Rev: D PO: PO038682 Line: 5
6 ea	Part: 646.3610 Filler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22196		Rev: N/C PO: PO038682 Line: 8
12 ea	Part: 646.3610 Filler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22196		Rev: N/C
Made in Canada.			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914370

Date: 05-Jan-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	- .9 mils) per drawing. Job: 22197 PO: PO038682 Line: 9		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>05/01/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: <u>SP18-01-11</u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			